



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-15103W6-3

Job Sheet 203711



Part No: RBE105-15103W6-3

Job Qty: 8 pcs 12 21

Part Name: Bonding Fixture Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/26/19

Job Tracking No:

Due Date: 1/17/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP REV:A 17.11.07 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-2500Y - 1	8 pcs	1/17/20	1/17/20	1.00	2.67	SL-2500Y - 1		JL 19-12-5
110	QC 2	8 pcs	1/17/20	1/17/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		JL
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

120	QC 8	8 pcs	1/17/20	0.00 0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	DAS
					QC 8 - 52	52
					QC 8 - 23	9-89 17/12/08
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130	QC 5	8 pcs	1/17/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
140	Outsource - 4 - Anodize	8 pcs	1/17/20	0.00 0.00	ULT002	2019-12-12
150	Packaging 2-1 - Receive - B4B	8 pcs	1/17/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	

NOT REQUIRED

DAS
52
9-89 17/12/08

2019-12-12

JAN 02 2020

				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
160 QC 6	8 pcs	1/17/20	0.00 0.00	QC 6 - 9	
				QC 6 - 68	JAN 07 2020 DAS 68
				QC 6 - 61	9-89
				QC 6 - 40	
				QC 6 - 81	
170 Packaging 3-1 - Stock - B4B	8 pcs	1/17/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	DAS 28 9-89
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	

				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	8 pcs	1/17/20	0.00 0.00	QC 21 - SA - 21	5-3
				QC 21 - SA - 70	21
				QC 21 - SA - 53	5-3

JAN 09 2020

GA159

Part Op 100 - (MORI SL2500Y LATHE) 1-Machine as per folio FB644 FOLIO REV: AA DWG REV: A 2-
Descriptions: Deburr
110 - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (QC5- Inspect part completeness to step on W/O)
140 - (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG: 45381 ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant Certificate of Conformity is required
150 - (Receive & Inspect for Damage & Mat'l Certs)
160 - (QC6- All purchased or subcontracted products)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

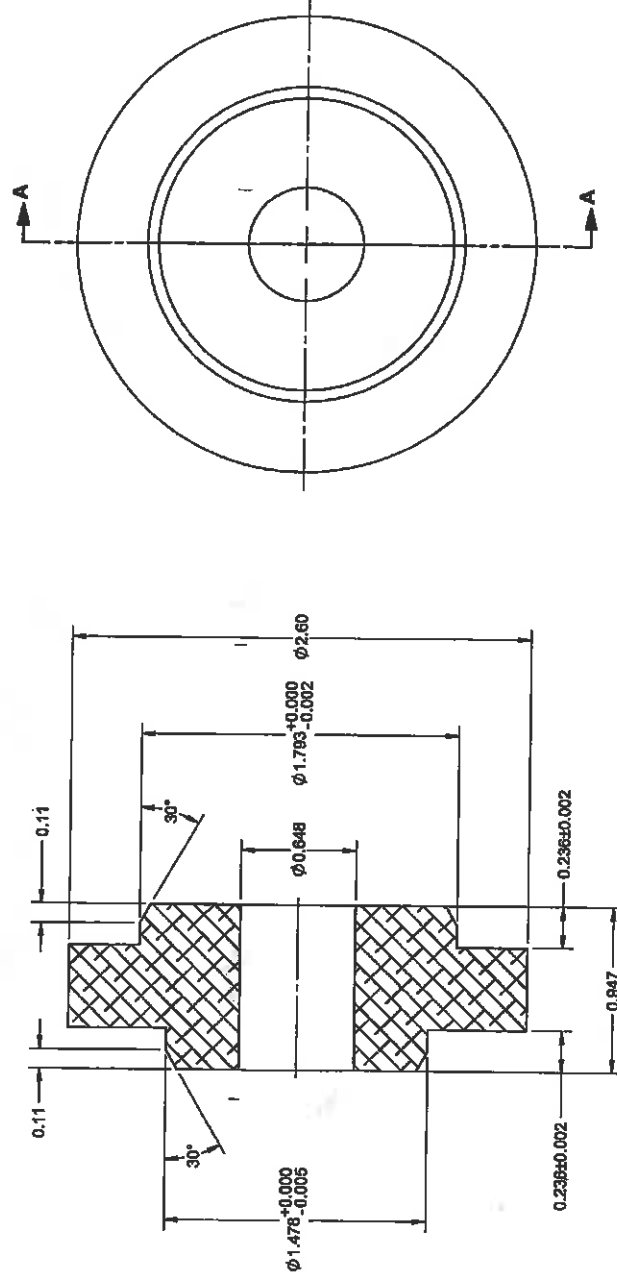
Part / Item	Component Name	Quantity	Operation	Container
M6061T6R3.000	6061-T6 Round Bar 3.000"	.6664 ft (.0833 ea)	100-SL-2500Y - 1	<u>5203779</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-SL-2500Y - 1	M6061T6R3.000 <u>2.750</u>	<u>1</u>	14	0

Part Specifications

Specifications could not be found.



92-1161
NO. 201178 WORK ORDER

THE AEROSPACE HANDBOOK Hamilton, Ontario, Canada

BONDING FIXTURE BUSHING

[illegible]

EW 17-688

NOTES:
1) MATERIAL: 8081-T6 PER DART M608178R
2) HEAT TREAT: N/A
3) FINISH: CLEAR ANODIZE
4) SPEC: MIL-A-8625F, TYPE II, CLASS I
5) BREAK ALL SHARP EDGES .015 x .45" OR .016R
6) IDENTIFICATION: N/A

4) SPEC: MIL-A-8625F, TYPE II, CLASS I
5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
6) IDENTIFICATION: N/A

NCR No.

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS042)			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
						Completed By	
						Lead hand / Supervisor	
		QC / QA Coordinator					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB045381



Supplier: ULT002-VC
Ultraspec Inc.
2600 De Miniac
St Laurent
QC
H4S 1V5 Canada
Phone: 5143371782
Fax: 5143371784

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045381
PO Date: 12/12/19
Due Date: 12/20/19
Purchase Order
Revision: DEC 17 2019
Revision Date: 12/17/19
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Pymt Terms: Net 30
Freight Terms: Prepaid REVISED
Special Comments:

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197497	RBE350A94-3701-00-01	RBE350A94-3701-00 Rev E	7 Degree M/R Rigging Tool (Outsource process-Anodize per QSI017 4.1.10.1), -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2 -Material type; 6061 -Certificate of Conformity is required	Firmed - X20		12/20/19	20 pcs	0 pcs	20 pcs	\$5.44/pcs	\$108.80
										JAN 02 2020		
2	197498	RBE350A94-3701-00-03	RBE350A94-3701-00 Rev E	6° Main Rotor Rigging Tool (Dual) (Outsource process-Anodize per QSI017 4.1.10.1), -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2 -Material type; 6061 -Certificate of Conformity is required	Firmed - X20		12/20/19	20 pcs	0 pcs	20 pcs	\$5.44/pcs	\$108.80
										JAN 02 2020		



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PURCHASE ORDER
POHB045381



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	203711	RBE105-15103W6-3	RBE105-15103W6 Rev A	Bonding Fixture Bushing (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Certificate of Conformity is required	Firmed X12	-	12/20/19	12 pcs	0 pcs	12 pcs	\$2.27/pcs	\$27.24
											JAN 02 2020	
											Grand Total:	\$244.84

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/17/19 9:19 AM Dart.Lavoie.Chantal



CERTIFICAT DE CONFORMITÉ / CERTIFICATE OF COMPLIANCE
BON DE LIVRAISON / PACKING SLIP
052162-1

BUYER: Dale Bates - INVOICING

Client / Customer:
DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Livrer À / Ship To:
DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Date	Genéré Par Generated By	Packaging Paquets	Vendor Code Code Vendeur	Transport	Customer PO / BC Client		
17-Dec-2019	Sami Sakkal	3 boxes			POHB045381		
#	No. de Serie / Part Number Line Item Details	Description/Information Additionnelle Additional Information	Commandée Ordered	Acceptée Accepted	Rejetée Rejected		
1	RBE350A94-3701-00-01 Rev. MAT: 6081-T6 Prog./Prime: /COMM.	RIGGING TOOL Job No./WO. 197497 BLACK ANODIZE PER MIL-A-8625, REV. F1, TYPE II, CLASS 2.	20	20	0		
2	RBE350A94-3701-00-03 Rev. MAT: 6081-T6 Prog./Prime: /COMM.	RIGGING TOOL Job No./WO. 197498 BLACK ANODIZE PER MIL-A-8625, REV. F1, TYPE II, CLASS 2.	20	20	0		
3	RBE105-15103W6-3 Rev. A MAT: ALUM Prog./Prime: /	BONDING FIXTURE BUSHING Job No./WO. 203711 CLEAR ANODIZE PER MIL-A-8625 REV.F TYPE 2 CLASS 1 HOT WATER SEAL	12	12	0	DAS 68 9-89	
RECEIVED JAN 02 2020 DART AEROSPACE LTD.							

CERTIFICATE OF COMPLIANCE : I certify that the parts included on this certificate have been processed as per specifications listed above and conform to all the requirements detailed in the contract or purchase order, this compliance is supported by a thorough inspection of parts and regular qualification of material processing facilities

Ultraspec Inc.
Authorized Signature :
Sami Sakkal

Parts
Received by : _____

All claims with reference to this order must be made within 30 days from receipt of good.